

OA 55 TC

CATEGORY FCAW Flux-Cored

TYPE Titanium -alloyed tubular wire on a C-Cr-Ti carbide basis for hardfacing.

APPLICATIONS Rebuilding and or protecting wear parts that faces severe impact combined with heavy abrasion.

PROPERTIES Very good wear resistance against abrasion combined with impact. The deposit gives already a very good hardness in the second layer thanks to the Titanium carbides. The choice for the buffer layer is depending on the base metal and not always necessary.

CLASSIFICATION

AWS	A 5.21:
EN ISO	14700: T Fe8
DIN	8555: MF 6-60-GP

SUITABLE FOR Hrc 54-56, hardfacing alloy for Cement crusher rollers, Mineral and brick industry, Hammers, Screw conveyers, gravel pumps, bucket collars, dredger teeth etc.

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	Cr	Ti	Mo
1.8	1.45	1.6	5-7	4.5	1-1.5

MECHANICAL PROPERTIES

Heat Treatment	Rp0,2 (N/mm ²)	Rm (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness Hrc
				-20°C	-40°C	-60°C	
AW							54-59

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spooling type	kg / spool / drum	kg / pallet
1.6	20-26	160-260	S-300 / Coil B-450 / Drum	15 / 25 / 300	1080 / 1000 / 600
2.0	22-26	240-280	S-300 / Coil B-450 / Drum	15 / 25 / 300	1080 / 1000 / 600
2.4	24-27	280-340	S-300 / Coil B-450 / Drum	15 / 25 / 300	1080 / 1000 / 600

REDRYING TEMPERATURE 150°C / 24hr.

STICK OUT 25-40 mm